

Date: Thursday, 17/08/2006 3:19:49 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI ACCESS STEP LH
<b>Job Number</b> : 28219	
<b>Estimate Number</b> : 11764	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206628022
<b>This Issue</b> : 17/08/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 27092	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 10/09/2006 <b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est Rev:D as per ECN 766 JLM	

### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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(3)

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-022 CHG 002

KS 06.08.30

2.0	28219A	206L /407 STEP ASSY, RH
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**Comment:** Sub-Component D2724-042 SUB-COMPONENT

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27317	Mounting Lug
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	D2731-7	Mounting Lug	
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B 22592 ✓

5.0	D2856400	Abrasion Strip
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**Comment:** Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty	Part #	Description	Batch
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2	D2856-400 6.9"	Abrasion Strip	
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B27545 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:19:49 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 28219

Part Number: D206628022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-043

LUG ASSY

B26945 7mic B27120 sm

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

M101291 ✓

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-13A

Bolt

M101594 ✓

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-15A

Bolt

M19185 ✓

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN960JD416

Washer

M19185 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

M19085 ✓

04/8/22 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 06/09/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:19:49 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 28219

Part Number: D206628022

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AL 06/08/30

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-022

Location: E

PPP Rev: E

DOCUMENT CONTROL

06/09/28 (3)

14.0

DC



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/29 (3)

Job Completion



u 06.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

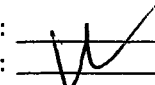

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:19:58 PM  
User: Linda Lacelle









# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, RH
Job Number	: 28219A	Part Number	: D2724042
Estimate Number	: 11703	Drawing Number	: D2724 REVC
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 17/08/2006 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 10/09/2006 Qty: 3 Um: Each
Previous Run	: 27092A		
Written By	: 		
Checked & Approved By	: 		
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
<div></div>		
<div>Comment: Qty.: 1.0000 Each(s)/Unit    Total : 3.0000 Each(s)</div> <div>Qty    Part #    Description    Batch:</div> <div>1    D2622-120C    Extrusion    <u>327077</u></div>		
<div>Check Material for any Dents or Defects</div> <div><i>PE. 06.09.06</i></div>		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<div></div>		
<div>Comment: LARGE FABRICATION RESOURCE 1</div> <div>Cut D2724-2 using D2622 extrusion as per Dwg D2724</div> <div>Deburr and bevel ends for welding</div> <div><i>PE. 06.09.06</i> <i>PE. 06.09.06</i></div>		
3.0	D2734	206 Step Endplate
<div></div>		
<div>Comment: Qty.: 2.0000 Each(s)/Unit    Total : 6.0000 Each(s)</div> <div>206 Step Endplate</div> <div>Pick:</div> <div>Qty    Part Number    Description    Batch</div> <div>2    D2734    End Cap    <u>327281</u> = <del>B</del></div> <div><i>PE. 06.09.06</i></div>		
4.0	D34581	PLATE
<div></div>		
<div>Comment: Qty.: 2.0000 Each(s)/Unit    Total : 6.0000 Each(s)</div> <div>Pick:</div> <div>Qty    Part Number    Description    Batch</div> <div>2    D3458-1    Plate    <u>327128</u></div> <div><i>PE. 06.09.06</i></div>		

WIO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 17/08/2006 3:19:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 28219A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	B27253

*LE. 06.09.04* 3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig  
DT (One End Only)  
A/R AL ROD Batch: M100660

Grind end cap welds flush

*LE. 06.09.12*  
*LE. 06.09.12*  
*LE. 06.09.12*  
3

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*06.08.16 (3)*  
*06/09/20 (3)*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 06.09.20 (3)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*LE. 06.09.21* 3

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig  
DT

A/R AL ROD Batch: M15689

*LE. 06.09.21* 3  
*LE. 06.09.21* 3  
*LE. 06.09.21* 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:19:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 28219A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Grind end plate flush.

FF 06.09.21 3

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/09/22 (3)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

06.09.27 (3)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

06/09/27 X 3

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-09-28 (3)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

06-09-28 (3)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/9/28 (3)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/P 06/9/28

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/29

u 06.09.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

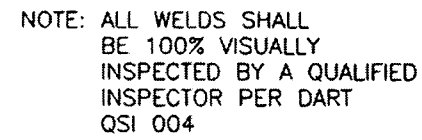
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



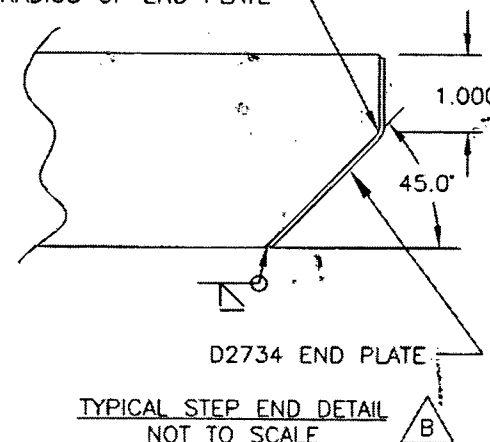
— REFER TO STEP  
END DETAIL

MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

1) MAKE FROM EXTRUSION D2622 TYPICAL S  
2) WELD PER DART QSI 004 NOT  
3) FINISH: CHEMICAL CONVERSION COAT. PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
4) ALL DIMENSIONS ARE IN INCHES  
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



TYPICAL STEP END DETAIL  
NOT TO SCALE

**REFERENCE ONLY**

RELEASED  
8.11.14

# DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<del>PH</del>	APPROVED	<del>PH</del>	DRAWING NO.	REV. C
				D2724	SHEET 1 OF 1
DATE				TITLE	SCALE
05.09.19				206L/407 STEP ASSEMBLY	NTS
A		97.12.04	NEW ISSUE		
B		98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES		
C		05.09.19	RE-DESIGN, ADD D3458-1/-3		